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D5374-3
Job Sheet 199009



Part No: D5374-3

Job Qty: 40 pcs

Part Name: Bushing



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/8/19

Job Tracking No:

Due Date: 8/29/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs	8/29/19	8/29/19	0.50	8.00	Hardinge - 1		[Signature]
120	QC 8	40 pcs	8/29/19	8/29/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		[Signature] 17/08/19
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Packaging 3-1 - Stock - B4B	40 pcs	8/29/19	0.00	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B	[Signature]	ST159
							Packaging 3 - 5 - B4B		

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					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	8/29/19	0.00 0.00		QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - 1-TURN AS PER FOLIO FB445 & DWG D5374
Descriptions: 120 - (QC8- Inspect parts - second check)
130 - (Identify as per dwg & Stock Location:)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	7.3200 ft (.183 ea)	100-Hardinge - 1	5150605

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303R0.500	7	48	0

DAS 77 9-89
AUG 26 2019 70 9-89

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.500Inches + 0.000 - 0.001	0.500 0.499	.497	Diameter
2	Bushing	0.313Inches + 0.000 - 0.003	0.313 0.310	.3118	Diameter
3	Bushing	30.000Degrees ± 0.500	30.500 29.500	30°	Angle
4	Bushing	0.035Inches + 0.030 - 0.010	0.065 0.025	.032	
5	Bushing	2.050Inches + 0.000 - 0.005	2.050 2.045	2.047	
6	Bushing	0.020Inches ± 0.030	0.050 (0.010)	.020	Radius
7	Bushing	0.050Inches + 0.000 - 0.005	0.050 0.045	.048	
8	Bushing	0.196Inches ± 0.005	0.201 0.191	.195	Diameter
9	Bushing	0.226Inches + 0.010 - 1.000	0.236 (0.774)	.228	
10	Bushing	90.000Degrees ± 0.500	90.500 89.500	90°	Angle

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Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function	
		Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread	
		Other/Details:			
		Completed By			
		Lead hand / Supervisor			
		QC / QA Coordinator			